

Date: Friday, 8/25/2006 11:21:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW INSTALLATION
Job Number : 28341	
Estimate Number : 10044	
P.O. Number :	Part Number : D044662011
This Issue : 8/25/2006	Drawing Number : D3075 REV A2 <i>under review</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : A2
Previous Run : 26250	Material :
Written By :	Due Date : 9/25/2006
Checked & Approved By :	Qty: 6 Um: Each
Comment : Est Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM	

Additional Product

Job Number:



cancel

Seq. #:	Machine Or Operation:	Description :
1.0	28341A	UNDER REVIEW R44 BEARPAW



Comment: Sub-Component R44 BEARPAW

2.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPPD044-662-011 CHG002

3.0	D2182B	Neoprene Cushion-.750 bl
-----	--------	--------------------------



Comment: Qty.: 0.2400 f(s)/Unit Total : 1.4400 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B028 Rubber Cushion

1 Paperwork package

4.0	D2274	Radius Block
-----	-------	--------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

5.0	D2529	Washer
-----	-------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 8/25/2006 11:21:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 28341

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2882

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3075-1 Bearpaw(REF)

4 D2882 Clamp

7.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-14A Bolt

8.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt

9.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer

10.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 8/25/2006 11:21:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 28341

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-662-011

Location: _____

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

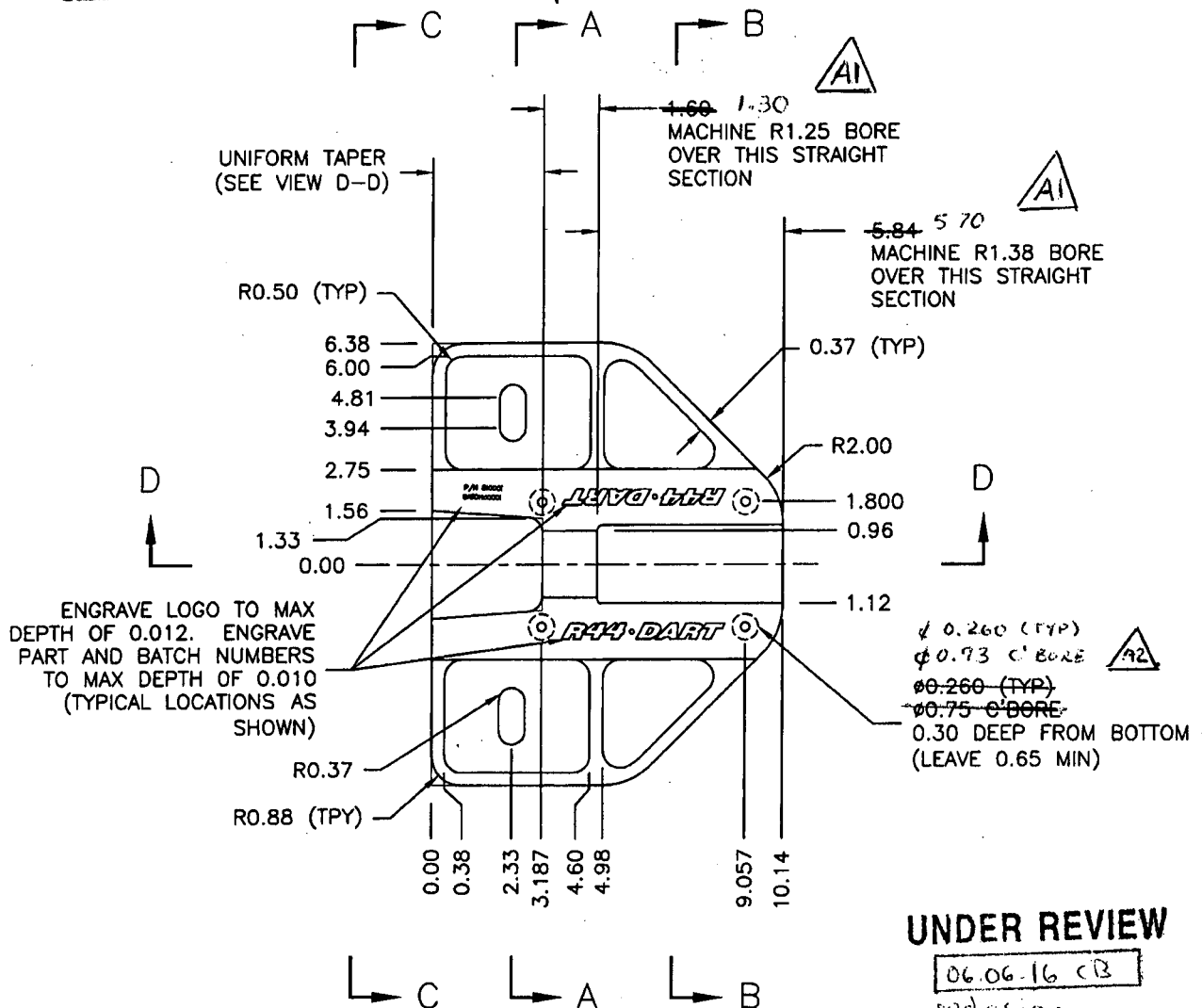
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3075	REV. A SHEET 1 OF 2
DATE 02.01.04		TITLE R44 BEARPAW	SCALE 1:5
A	02.01.04	NEW ISSUE	
A1	RF 02.02.01	1.30 WAS 1.60 ; 5.70 WAS 5.84	
A2	RF 03.01.06	Ø 0.93 WAS Ø 0.75	

RELEASED
02.01.10 *[Signature]*

D3075-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

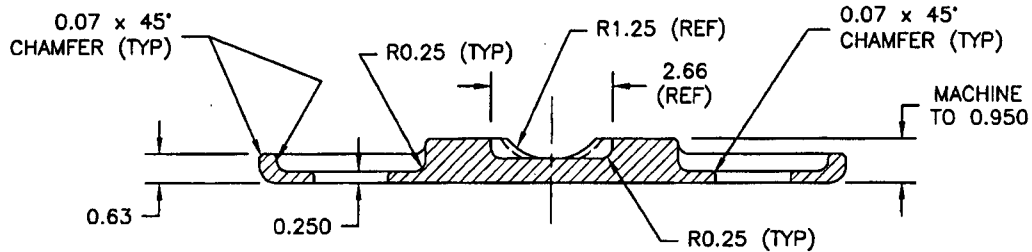
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CHECKED #	APPROVED #	DRAWING NO. D3075	REV. A SHEET 2 OF 2
DATE 02.01.04		TITLE R44 BEARPAW	SCALE 1:4

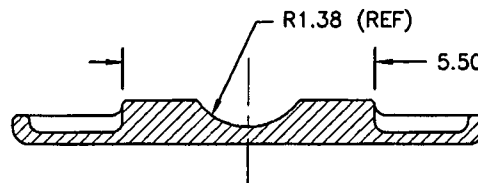
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02.01.10



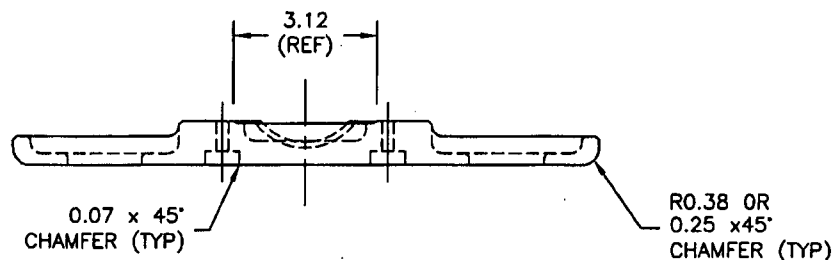
UNDER REVIEW

06.06.16 CB
redesign

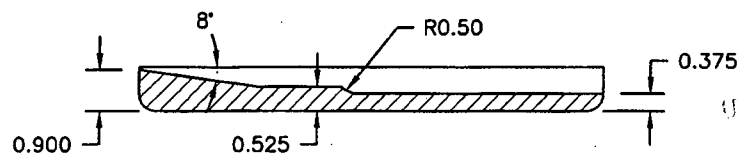
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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Date: Friday, 8/25/2006 11:21:10 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	UNDER REVIEW R44 BEARPAW
Job Number :	28341A		
Estimate Number :	10100		
P.O. Number :		Part Number :	D30751
This Issue :	8/25/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	UNDER REVIEW
First Issue :	/ /	Project Number :	N/A
Previous Run :	26250A	Drawing Revision :	A2
		Material :	
Written By :		Due Date :	9/25/2006
Checked & Approved By :		Qty:	12
Comment :	Est Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM		
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 1.8949 sf(s)/Unit Total : 22.7388 sf(s)
 Pick:
 blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12
 Material: Black UHMW 1"(MUHMWB10)
 Batch: _____

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1

3-Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 8/25/2006 11:21:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UNDER REVIEW R44 BEARPAW

Job Number: 28341A

Part Number: D30751

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: R44 Bearpaw		Part Number:	D3075-1
Inspection Dwg: D3075 Rev: A2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

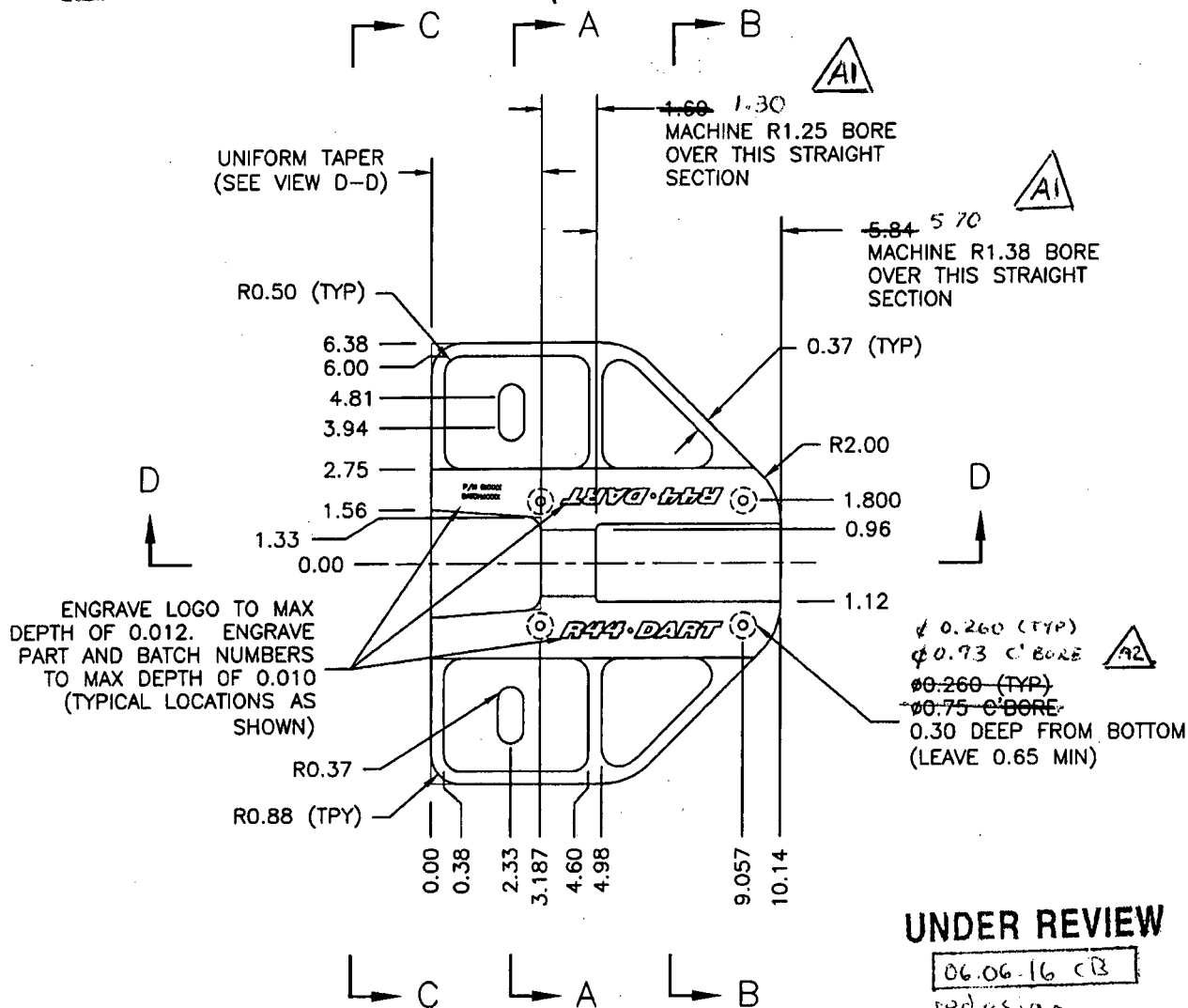
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010					
B	0.63	+/-0.030					
C	0.250	+/-0.010					
D	0.950	+0.030/-0.010					
E	5.50	+/-0.030					
F	0.25 x 45°	+/-0.030					
G	0.900	+/-0.010					
H	0.375	+/-0.010					
I	1.30	+/-0.030					
J	5.70	+/-0.030					
K	0.37	+/-0.030					
L	3.600	+/-0.010					
M	0.260	+0.005/-0.000					
N	0.93	+/-0.030					
O	0.30	+0.030/-0.000					
P	1.08	+/-0.030					
Q	5.870	+/-0.010					
R	10.14	+/-0.030					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

DART

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A2	RF 03.01.06	φ 0.93 WAS φ 0.75	

RELEASED
02.01.10 *[Signature]*

D3075-1 BEARPAW

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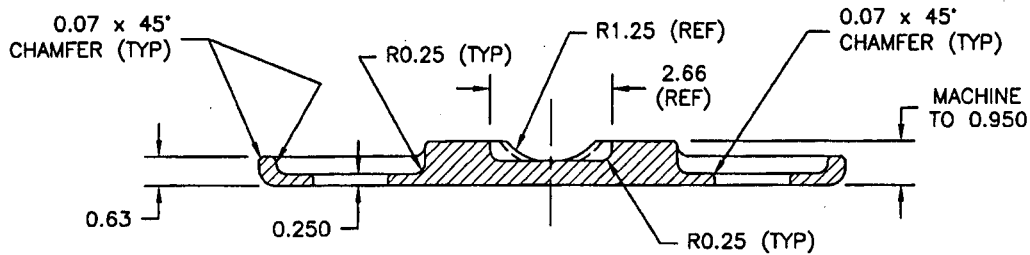
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CHECKED #	APPROVED #	DRAWING NO. D3075	REV. A SHEET 2 OF 2
DATE 02.01.04		TITLE R44 BEARPAW	SCALE 1:4

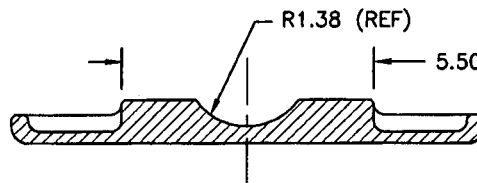
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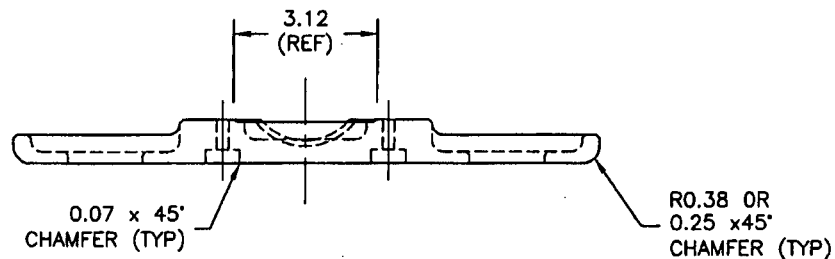
SECTION A-A

UNDER REVIEW

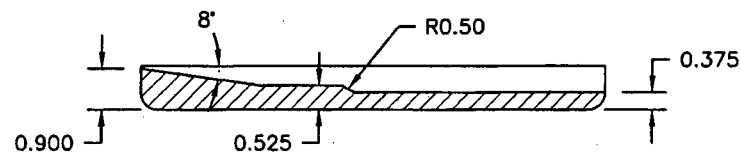
06.06.16 CB
redesign



SECTION B-B



SECTION C-C



SECTION D-D

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